

Date: Monday, 1/7/2008 3:38:40 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GASKET
Job Number	: 36635		
Estimate Number	: 12723		
P.O. Number	: N/A	Part Number	: D353613
This Issue	: 1/7/2008	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3536 REV A
First Issue	: N/A	Project Number	: N/A
Previous Run	: 35565	Drawing Revision	: A
		Material	: N/A
Written By	: <u> </u>	Due Date	: 1/21/2008
Checked & Approved By	: <u> </u>	Qty:	20 Um: Each
Comment	: Est Rev: A New Issue 07-02-14 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
---------	-----------------------	--------------

1.0	MNEO60S063	NEOPRENE SHEET 0.063
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22.5TB2



Comment: Qty.: 0.8682 sf(s)/Unit Total: 17.3649 sf(s)

NEOPRENE SHEET 0.063

Batch: 166614 HB 8-1-9

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3536

Dwg Rev: Prog Rev:

HB 8-1-9

26

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



HB 8-1-9



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

08/11/07 226

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

8/1/9

SP

26x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 20 Date: 08/01/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 3:38:40 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 36635

Part Number: D353613

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(26)

Comment: FINAL INSPECTION/W/O RELEASE

RD 08/01/11

Job Completion



U 08/01/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	36635
Description: Gasket		Part Number:	D3536-13
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.90	+/-0.030	32.90				
29.40	+/-0.030	29.40				
27.40	+/-0.030	27.40				
23.90	+/-0.030	23.90				
18.98	+/-0.030	18.98				
14.07	+/-0.030	14.07				
9.15	+/-0.030	9.15				
5.65	+/-0.030	5.65				
3.90	+/-0.030	3.90	*			
8.00	+/-0.030	8.00	*			
14.00	+/-0.030	14.00	*			
20.00	+/-0.030	20.00	*			
1.89	+/-0.030	1.89	*			
0.30	+/-0.030	.30	*			
0.30	+/-0.030	.30	*			
Ø0.19	+0.005/-0.001	.19	*			

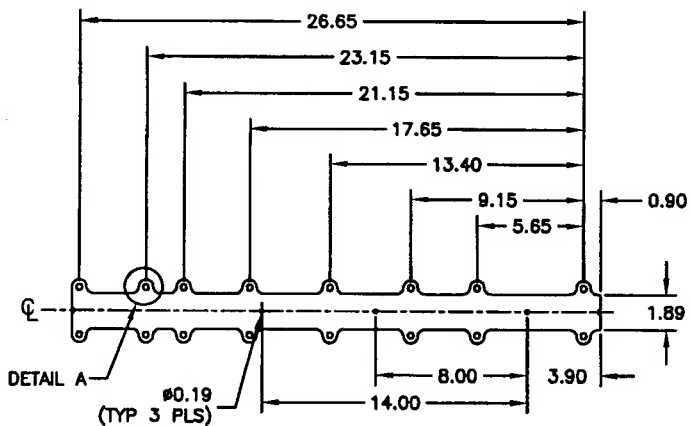
Measured by:	IB	Audited by:	↓	Prototype Approval:	N/A
Date:	8-1-9	Date:	08/01/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM	AF

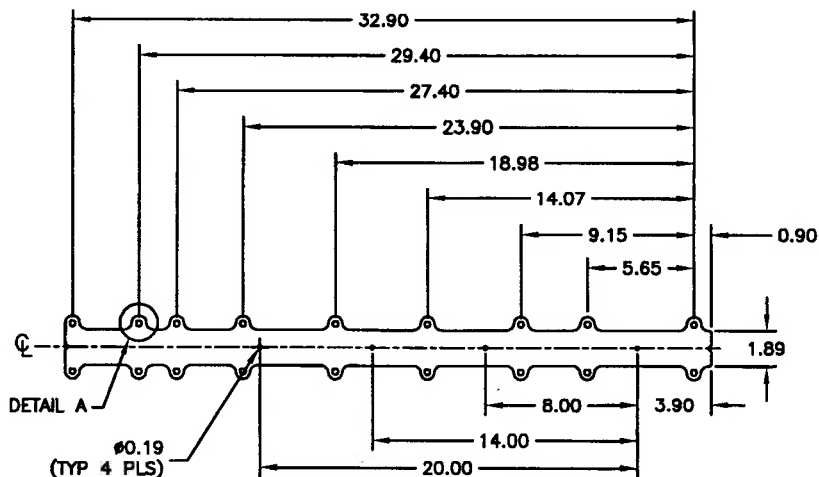
DART

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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 1 OF 6
A	06.10.25	NEW ISSUE		SCALE
				1:10

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09.02.12



D3536-11 GASKET




D3536-13 GASKET

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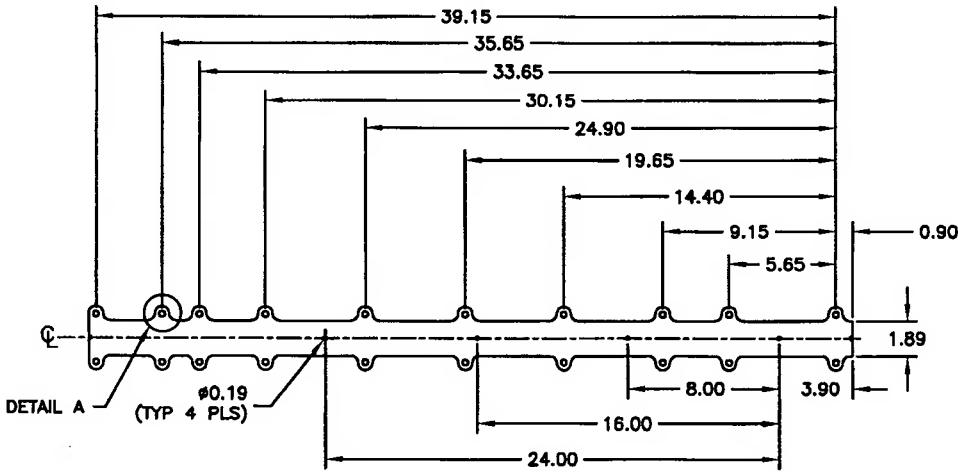
NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

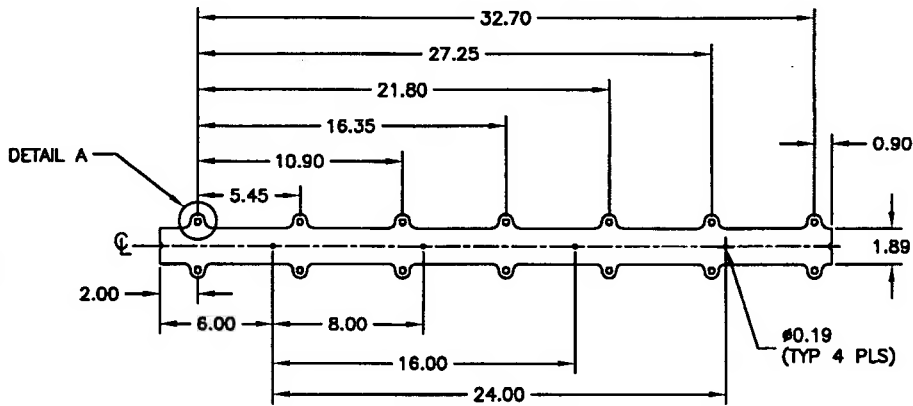
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DATE 06.10.25	TITLE GASKET		SCALE 1:10

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D3536-15 GASKET



D3536-21 GASKET

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NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S-063)
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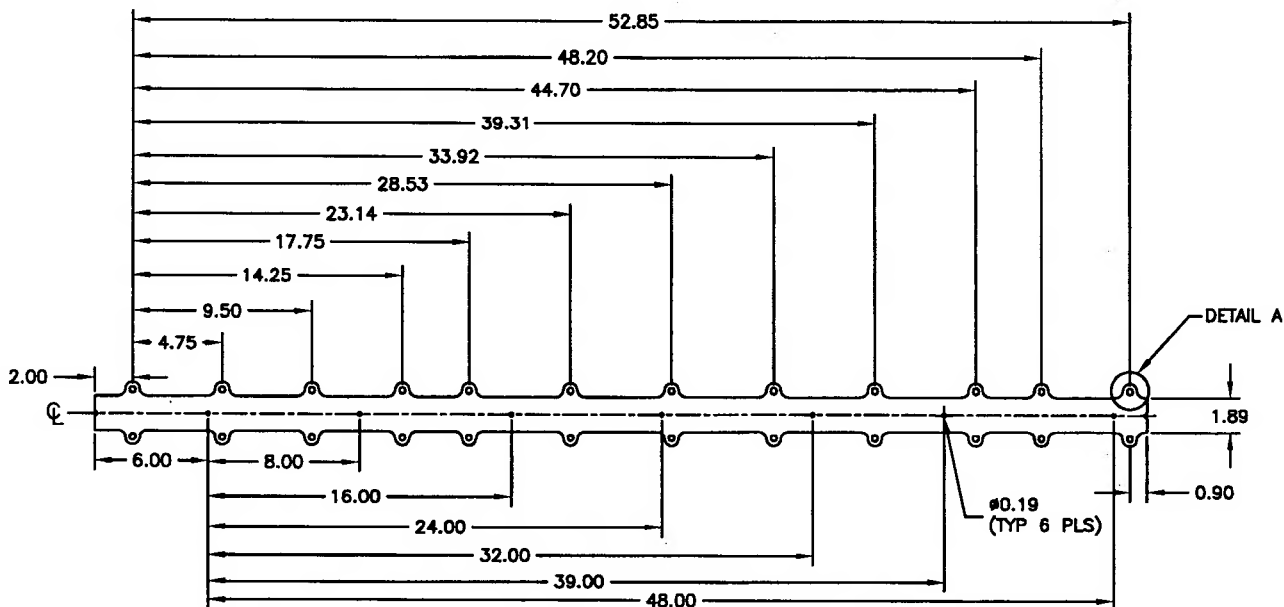
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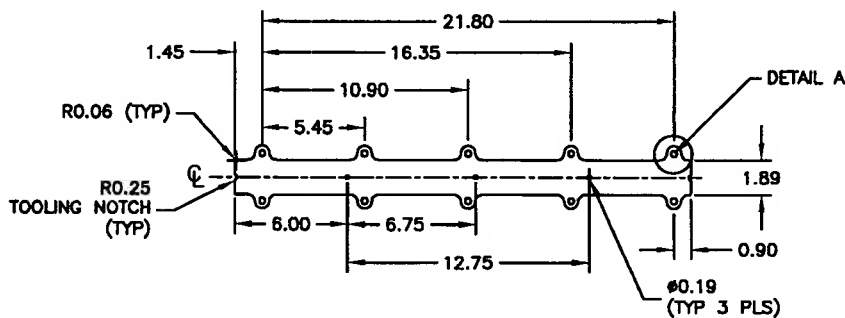
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		DRAWING NO.	D3536	SHEET 3 OF 6
		SCALE	1:10	

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D3536-23 GASKET



D3536-25 GASKET

NOTES

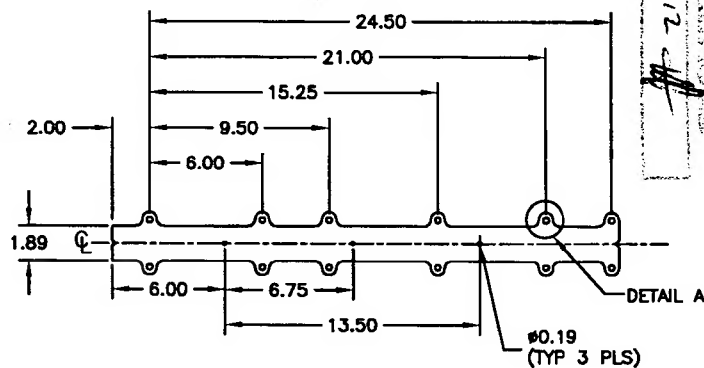
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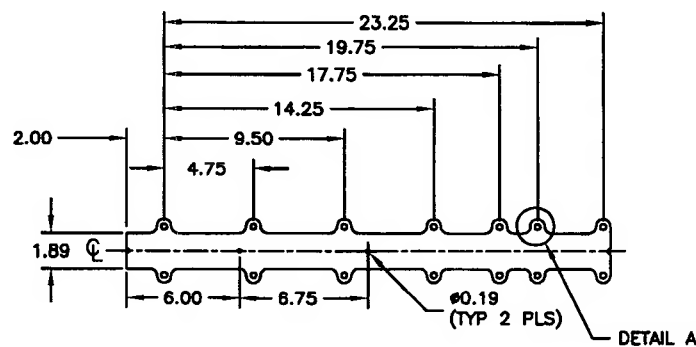
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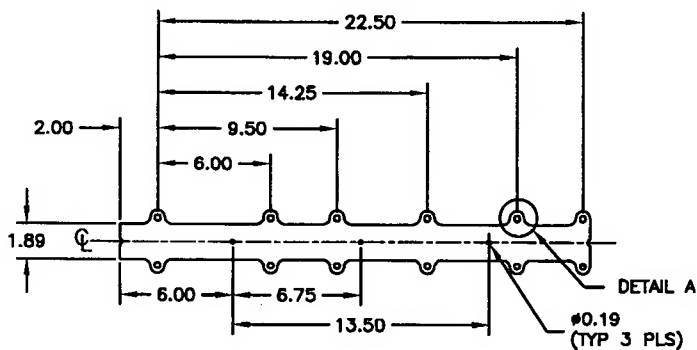
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D3536-33 GASKET



D3536-35 GASKET



D3536-31 GASKET

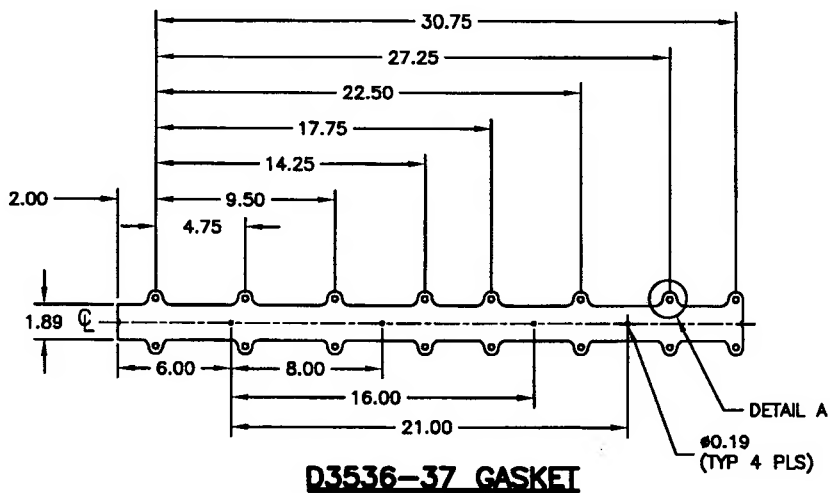
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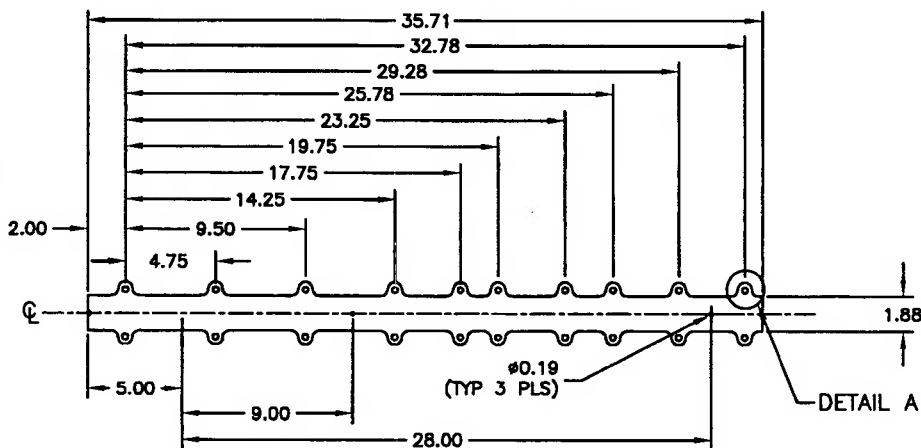
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DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 5 OF 6
				SCALE 1:10



D3536-37 GASKET



D3536-39 GASKET

NOTES

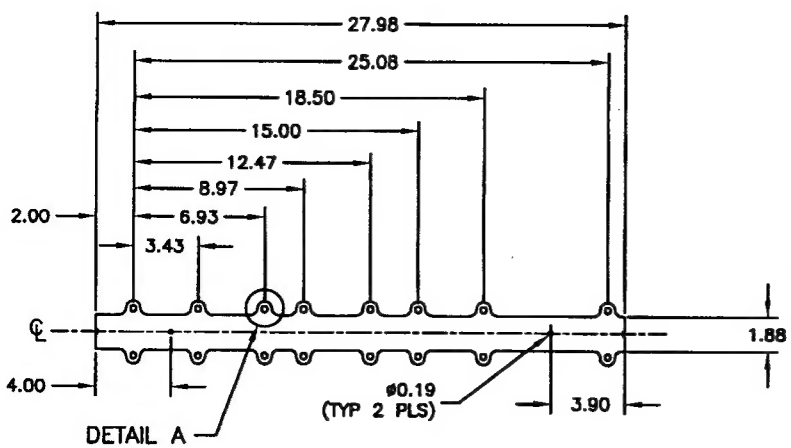
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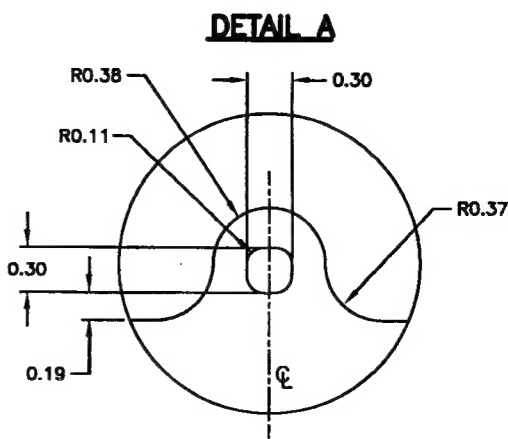


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D3536-41 GASKET



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